

Claims

1. A coated board product, which has one or more fiber plies and whose outside plies consist of bleached chemical pulp and middle plies of pulp
5 and/or broke and which board has a basis weight of 150-400 g/m², said board having a top side and a backing side, the production of said product involving the use of a surface conditioning device functioning as a calender and comprising:
a fixed support element (14),
10 a flexible jacket (12) fitted around the fixed support element (14), such that a board web (80) travels between the jacket (12) and a counter-roll (22), a load element (18, 22) provided in connection with the support element (14), such that the flexible jacket (12) is applied by the load element (18, 22) against the heatable counter-roll (22), the board web (80) present between
15 the jacket (12) and the counter-roll (22) becoming calendered, and at least one end wall of the calendering device mounted on the end of the flexible jacket in such a way that the flexible jacket (12) is attached to an end wall (24, 26) and the jacket (12) is rotated along with the end wall (24, 26) by means of a drive mechanism, **characterized** in that prior to the coating
20 process the manufacturing of the product involves the use of one or more surface conditioning devices functioning as a precalender and the coated product has surface properties on the top side of the board as follows:

PPS-s10 roughness (ISO 8791-4)	0,5-2,0 µm
Hunter gloss (ISO/DIS8254)	40-80%,

25 and that the product has a density (SCAN-P7:75) within the range of 500-1000 kg/m³.

2. A product as set forth in claim 1, **characterized** in that the top side is coated one or more times.

3. A product as set forth in claim 1-2, **characterized** in that the backing side is uncoated.
4. A product as set forth in claim 1-2, **characterized** in that the backing side is coated at least once.
5. A product as set forth in any of the preceding claims, **characterized** in that the basis weight is within the range of 180-350 g/m².
- 10 6. A product as set forth in any of claims 1-5, **characterized** in that the basis weight is within the range of 180-300 g/m².
7. A product as set forth in any of claims 1-6, **characterized** in that the top side has a Bendtsen roughness (SCAN-P21:67) within the range of 0-50
15 ml/min.
8. A product as set forth in any of claims 1-6, **characterized** in that the top side has a Bendtsen roughness (SCAN-P21:67) within the range of 0-20
ml/min.
- 20 9. A product as set forth in any of claims 1-8, **characterized** in that the top side has a PPS-s10 roughness (ISO 87911-4) within the range of 0,8-1,5 µm.
- 25 10. A product as set forth in any of claims 1-9, **characterized** in that the top side has a Hunter gloss (ISO/DIS 8254) within the range of 45-65%.
11. A product as set forth in any of the preceding claims, **characterized** in that it has a density (SCAN-P7:75) within the range of 750-1000 kg/m³.

12. A product as set forth in any of claims 1-11, **characterized** in that the product calendering has also involved the use of a single- or multi-nip machine and/or soft calender.
- 5 13. A product as set forth in any of claims 1-12, **characterized** in that its precalendering has involved the use of board surface wetting.
14. A product as set forth in any of claims 1-12, **characterized** in that its precalendering has not involved the use of board surface wetting.
- 10 15. A method for making a coated board product, said board product having two or more fiber plies and having its outside plies consisting of bleached chemical pulp and middle plies of pulp and/or broke, and said board having a basis weight of 150-400 g/m², **characterized** in that the method involves
- 15 introducing a web to be coated into a surface conditioning device, comprising:
- a fixed support element (14),
- a flexible jacket (12) fitted around the fixed support element (14), such that a board web (80) travels between the jacket (12) and a counter-roll (22),
- 20 a load element (18, 22) provided in connection with the support element (14), such that the flexible jacket (12) is applied by the load element (18, 22) against the heatable counter-roll (22), the board web (80) present between the jacket (12) and the counter-roll (22) becoming calendered, and at least one end wall of the calendering device mounted on the end of the flexible
- 25 jacket in such a way that the flexible jacket (12) is attached to an end wall (24, 26) and the jacket (12) is rotated along with the end wall (24, 26) by means of a drive mechanism and the web is precalendered with said surface conditioning device.
- 30 16. A method as set forth in claim 15, **characterized** in that the precalendering involves the use of surface wetting.